

# Work Order ID 79661

\*79661\*

Page 1

February-01-12 11:26:27 AM

Item ID: D206-667-147TRN

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Crosstube Assembly, Mid Fwd

Start Date: 31/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/01 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-147	A								

100

0.00

\*100\*

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DTxxxx on both ends as per Folio FB029

2-Turn first side as per Folio FB029

3-File down transition lines smooth.

FOLIO REV: HA

DWG REV: A

110

QC1- Inspect dimensions to dimension sheet

0.00

\*110\*

QC

Memo

0.00

Quality Control

1 Ø  
KC/gmml 12/03/30

1 Ø  
KC/gmml 12/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79661****\*79661\***

Page 2

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Item Name: Crosstube Assembly, Mid Fwd

Start Date: 31/01/2012 Start Qty: 1.00

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Required Date: 20/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	MORI SEIKI CNC LATHE LARGE	0.00							
<b>*120*</b>									
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FB029 2-File down transition lines smooth. 3-Remove sand and plugs FOLIO REV: <u>AA</u> DWG REV: <u>A</u>								
130	QC1- Inspect dimensions to dimension sheet	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

1  $\emptyset$   
KC/amm.L 12/03/30

1  $\emptyset$   
KC/amm.L 12/03/30  
12-4-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Assembly, Mid Fwd

Start Date: 31/01/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

145

0.00

**\*145\***

Crosstubes

Memo

0.00

Crosstubes

GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

MO

12-4-2

150

Crosstubes Chemical Conversion

0.00

**\*150\***

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

MO

12-4-2

160

QC - Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

QC7

12-4-2

PTO

W/O: 79661		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-4-2	160	Stand read QC7 Already done <i>[Signature]</i>	<i>[Signature]</i>	12-4-2				

Part No: D206-667-147TRN PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Start Date: 31/01/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Packaging	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging	Identify and stock in kanban rack Location: <u>LG KC</u>		<u>99999/KC</u>						
				12/4/02					
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12-04-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

February-01-12 11:26:31 AM

Page 1

Work Order ID: 79661

\*79661\*

Parent Item: D206-667-147TRN

\*D206-667-147TRN\*

Parent Item Name: Crosstube Assembly, Mid Fwd

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 11.01.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6002-115		Manufactured	No			100	Each	8.0000	1	1			

\*D6002-115\*

Crosstube Material

\*\*

Location

Loc Qty

Loc Code

LG

8

34684

1

34776

7

MANL 12/03/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 79661
<b>Description:</b> Crosstube Assembly, Mid Fwd		<b>Part Number:</b> D206-667-147TRN
<b>Inspection Dwg:</b> D206-667-147 Rev: A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244	✓		vern	CNC-08
	1.984	+0.005/-0.000	1.988	✓			
	2.019	+0.005/-0.000	2.024	✓			
	2.058	+0.005/-0.000	2.062	✓			
	2.097	+0.005/-0.000	2.100	✓			
	2.136	+0.005/-0.000	2.136	✓			
	2.176	+0.005/-0.000	2.179	✓			
	0.125	+/-0.010	.125	✓		vern	CNC-08
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.00	✓		II	
	R0.063	+/-0.010	.063	✓		II	
	4.438	+/-0.030	4.438	✓		vern	CNC-08
SIDE B	2.240	+0.005/-0.000	2.245	✓		vern	CNC-08
	1.984	+0.005/-0.000	1.987	✓			
	2.019	+0.005/-0.000	2.022	✓			
	2.058	+0.005/-0.000	2.063	✓			
	2.097	+0.005/-0.000	2.100	✓			
	2.136	+0.005/-0.000	2.137	✓			
	2.176	+0.005/-0.000	2.177	✓			
	0.125	+/-0.010	.125	✓		vern	CNC-08
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.00	✓		II	
	R0.063	+/-0.010	.063	✓		II	
	4.438	+/-0.030	4.438	✓		vern	CNC-08
	99.84	+/-0.020	99.840	✓		tape	MM-02

<b>Measured by:</b> mm.l/kc	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 12/03/29	<b>Date:</b> 12-4-2	<b>Date:</b>
<b>Rev</b>	<b>Date</b>	<b>Change</b>
A	11.06.21	New Issue
	<b>Revised by</b>	<b>Approved</b>
	KJ	[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## ULTRA SONIC MEASUREMENTS

Side	LOCATION on tube	R1	R2	R3	R4
A		.137	.183		
		.146	.194		
		.159	.203		
		.151	.190		

B		.134	.181		
		.151	.196		
		.160	.210		
		.147	.196		

Part number	D206-667-147 TRN.
Batch number	79661
Measured By	KC 12/4/02

Item	Qty -147	Part Number	Description
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6002-115  
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON  
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY.  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI  
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE  
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS  
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

UNCONTROLLED  
SUBJECT TO

NO. 79661 M.L.J  
12/02/01

DEO ATTACHED

ECO #11-615  
11.07.28

UNDER REVIEW

RELEASED  
2011-05-26  
JNT

A	NEW ISSUE	CP	10.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D206-667-147	REV. A SHEET 1 OF 4
TITLE CROSSTUBE ASSY (206L MID FWD)	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

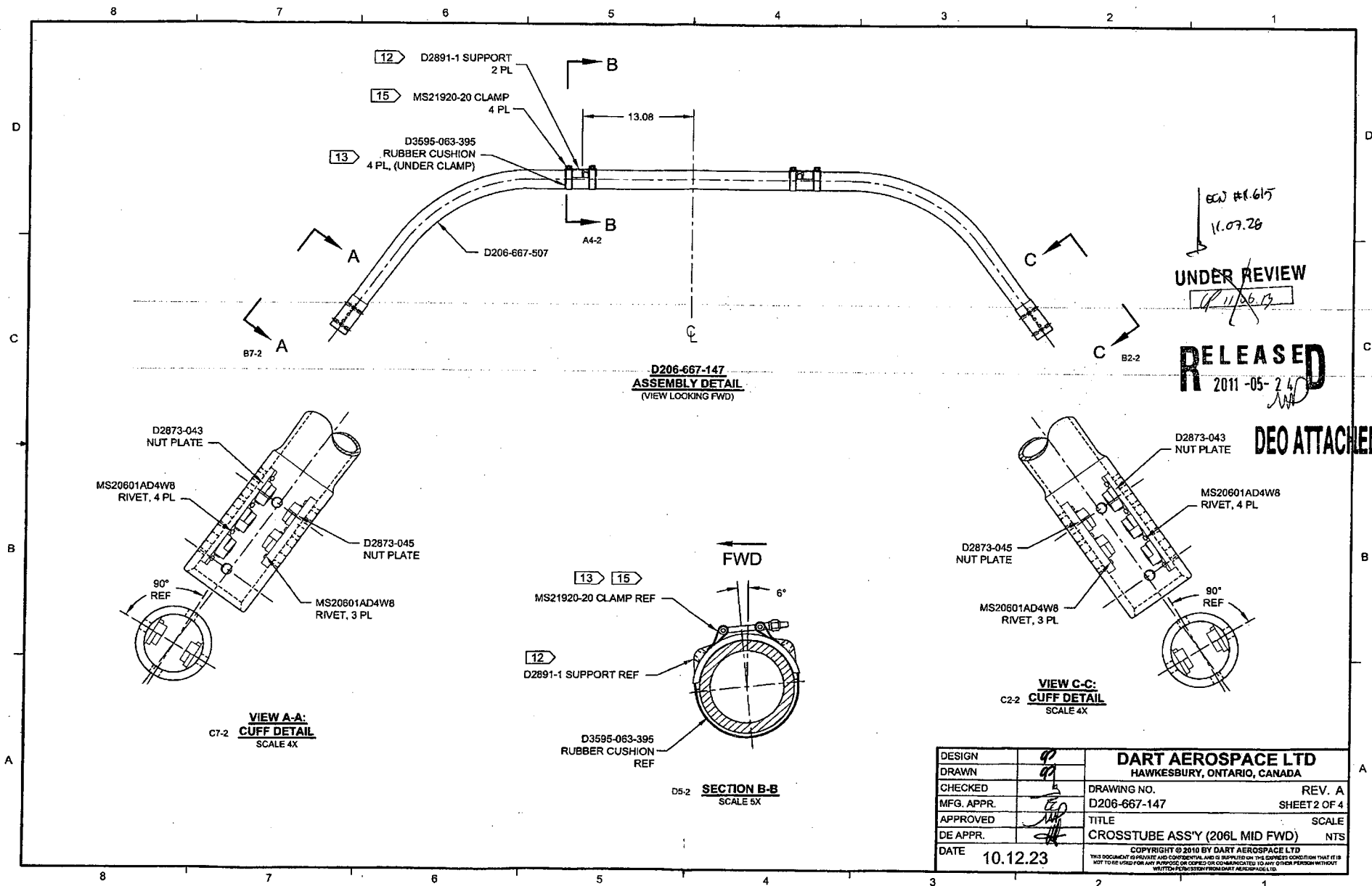
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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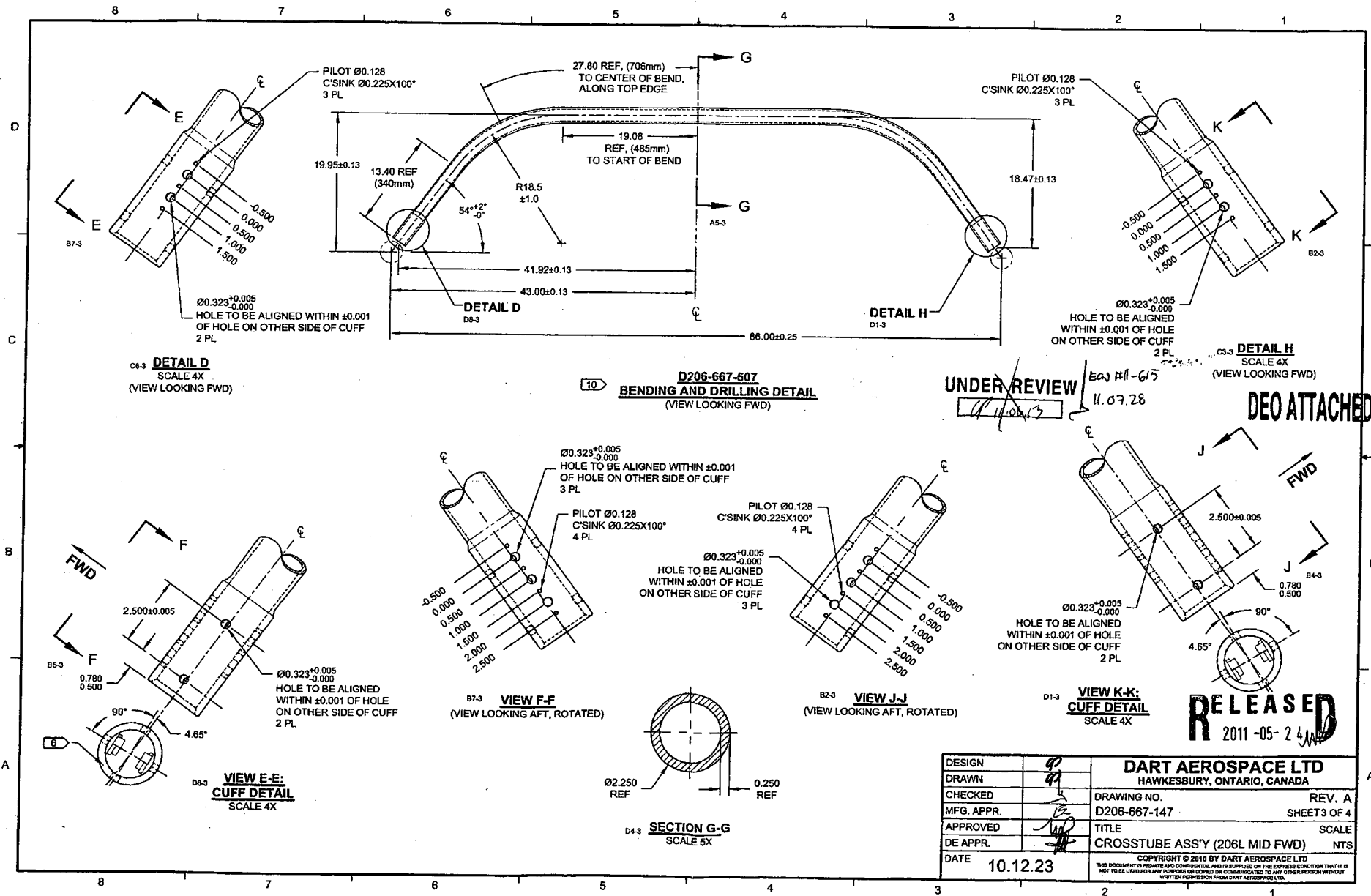
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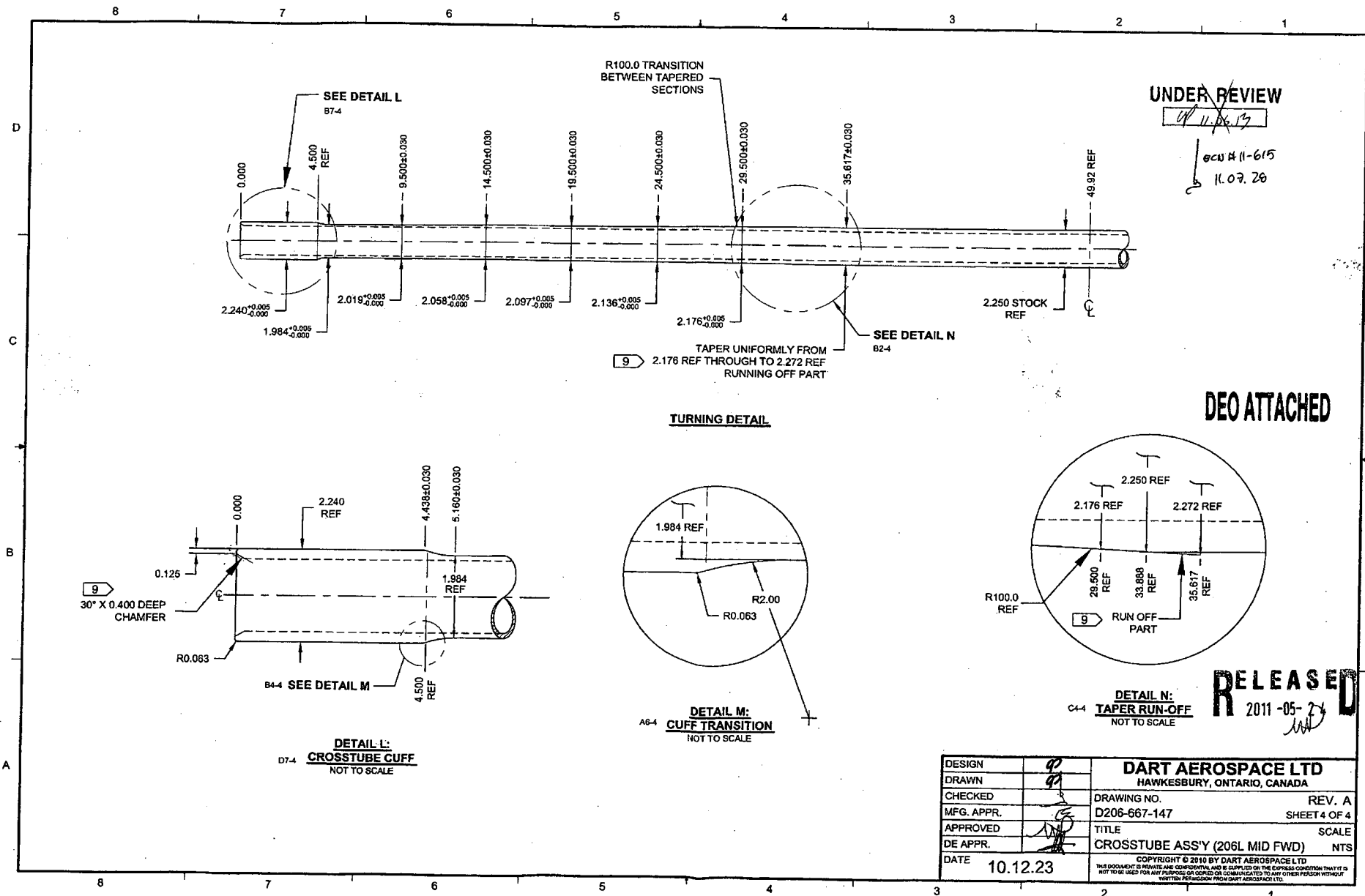
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79661

DRAWING NO. D206-667-147	TITLE CROSSTUBE ASS'Y (206L MID FWD)	REV. A	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D206-667-147-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>BS</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL.

**CHANGE:****IS:**

Item	Qty -147	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

**WAS:**

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 &amp; 15, SHEET 1 IS AMENDED AS FOLLOWS:

**IS:**

- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

**WAS:**

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
2011-07-28  
*MD*

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